

**Work Order ID 64386**

Friday, December 03, 2010 11:30:39 AM



Page 1

Item ID: D407-802-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, RH

Start Date: 12/3/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: 10/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-012 CHG001

*8/16/06**PTD m/a*  
*8*

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*JB* *CU**11/06/01*

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/16/06**(42)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B467-002 PAR #: \_\_\_\_\_ Fault Category: Production Engineering NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>B6686</u>		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			
<u>4/6/06</u>	<u>#110</u>	<u>wrong part in parts list</u> <u>R.L. who was created incorrectly</u> <u>+ version wrong</u> <u>D4106-3 should be</u> <u>D4106-3</u>		<u>→ remove incorrect part</u> <u>and replace with D4106-3</u> <u>B#</u>			<u>4/6/06</u>
				<u>→ correct w/o + Bm.</u> <u>And copy all correctly corrected</u> <u>Bm as reqd.</u>			<u>4/6/06</u>

NOTE: Date & initial all entries

**Work Order ID 64386**

Friday, December 03, 2010 11:30:39 AM



Page 2

Item ID: D407-802-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, RH

Start Date: 12/3/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-012								
	Location: _____								
	PPP rev: <u>DRAFT</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 03, 2010 11:30:45 AM

Page 1

Work Order ID: 64386

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.12.02 per revA DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-15 Door Prop		Manufactured	No			105	Each	1.0000	1	2			
-----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST272A

1

63012

1

D3622-5 Ball Stud		Manufactured	No			105	Each	0.0000	2	4			
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4106-2 Sill Doulber, RH		Manufactured	No			105	Each	0.0000	1	2			
-----------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4106-4 Crew Door Doulber, RH		Manufactured	No			105	Each	0.0000	1	2			
----------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4106-5 Spacer, Sill Doulber		Manufactured	No			105	Each	3.0000	1	2			
---------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST127

3

62296

3

D4106-7 Template		Manufactured	No			105	Each	2.0000	1	2			
---------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST124

2

62295

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Friday, December 03, 2010 11:30:45 AM

Work Order ID: 64386

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

CR3523-4-02

Purchased

No

105

Each

474.0000

26

52

✓



S  
RIVET



116915 3749 B

117291 10X

~~115768~~

Location

Loc Qty

Loc Code

ST312

300

115768

300

ST313

174

113064

74

116022

100

CR3523-4-4

Purchased

No

105

Each

88.0000

4

8

✓



S  
Rivet



JB

h

Location

Loc Qty

Loc Code

ST314

88

115768

88

CR3523-4-5

Purchased

No

105

Each

95.0000

3

6

✓



S  
Rivet



115768

117423

JB

h

Location

Loc Qty

Loc Code

ST314

95

115768

95

CR3523-4-6

Purchased

No

105

Each

80.0000

8

16

✓



S  
Rivet



JB

11/06/01

Location

Loc Qty

Loc Code

ST314

80

115768

80

115768

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

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Friday, December 03, 2010 11:30:45 AM

Work Order ID: 64386

Parent Item: D407-802-012

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

CR3523-4-07

Purchased

No

105

Each

69.0000

7

14

✓



RIVET

Location

Loc Qty

Loc Code

ST313

69

17768

69

17768

MS20426AD4-5

Purchased

No

105

Each

5,731.000

4

8

✓



Rivet

Location

Loc Qty

Loc Code

ST317

5731

6733

749

6874

4982

6733

MS21073L5

Purchased

No

105

Each

74.0000

2

4

✓



nut plate

Location

Loc Qty

Loc Code

ST303

74

113660

74

113660X1

NAS1149C0532R

Purchased

No

105

Each

278.0000

6

12

✓



WASHER

Location

Loc Qty

Loc Code

ST297

278

114348

8

115531

70

116289

200

116513

JB 11/06/01

Friday, December 03, 2010 11:30:45 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Friday, December 03, 2010 11:30:45 AM

Work Order ID: 64386



Parent Item: D407-802-012



Parent Item Name: Crew Door Opener Installation, RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0563R

Purchased

No

105

Each

148.0000

6

12

✓



112532 JB 11/06/01

Washer

Location

Loc Qty

Loc Code

ST297

148

115768

148

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D407-802-1  
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## 5.0 PARTS LIST

### 5.1 D407-802-011/-012 Crew Door Opener Kits

Qty -011	Qty -012	Part Number	Description
		D407-802-011	CREW DOOR OPENER KIT, LH
		D407-802-012	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		<del>D4106-1</del>	SILL DOUBLER, LH
	1	D4106-2	SILL DOUBLER, RH
1		<del>D4106-3</del>	CREW DOOR DOUBLER, LH
	1	D4106-4	CREW DOOR DOUBLER, RH
1	1	D4106-5	SPACER, SILL DOUBLER
1	1	D4106-7	TEMPLATE
26	26	CR3523-4-2	RIVET
4	4	CR3523-4-4	RIVET
3	3	CR3523-4-5	RIVET
8	8	CR3523-4-6	RIVET
7	7	CR3523-4-7	RIVET
4	4	MS20426AD4-5	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

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Revision: A  
Date: 10.10.13

